Work Order ID Friday, September 06, 201			*106	3573*			R	JSH		Page 1
Item ID: D3870-5 Revision ID: Item Name: Mount, Fw	yd Upper		Accept	*N900	040	100	ገ*	Setup Sta		S1*
Start Date: 9/6/2013 Required Date: 9/12/2013 Reference:	Start Qty: 2.00	*2/ *p	* *11*	Cust Item l Customer:	D:					
Approvals: Process	Plan: WF.	Date: 13-9	- (Tooling:	D	ate:		I	Run Sta	I/	R1*
		Date:	SPC (Y/N): .,r;	D	ate:			Sto	^{op} *N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	Revision Nbr									
D3870 A	1									
100 Waterjet	FLOW WATER JET Memo		0.00	,				O		Ac 13129
FLOW CNC Waterjet .	Dwg Rev:_ Prog Rev:_	Dwg D3870 A ges and holes if nece	ssary	•			12	٥		13.09 JMBC
110	QC2- Inspect parts off m	nachine FAI/FAIB	0.00					•.		
110 QC	Memo		0.00					O		Ac. 13,09.
Quality Control							12	0		13109. JM13
ზ *⁄1 2∩*	QC8- Inspect parts - seco	ond check	0.00 27	, 9			1/			
120 */120* Quality Control 2/ Benio au 2 OCS	Memo Dell. Drug		0.00 27 0.00 3 9 0 0.00 3 0)			12			Ss 13/3
· Vene	1.	13	9-89				12			

NCR:	Yes	1	No
NCN.	163	,	110

WORK ORDER NON-CONFORMANCE / UPDATE

DOACH	Date:	,	,	
QA Closed	13/09/17 Date:(3/09:13	ъ, З		•

										QA Closedy	Date.	YU//S
Work Order:	10	065	572	>	DISPOSITION				AGAINST DEI	PARTMENT	PROCESS	
Part No.	D 13-	38° 30	70- 21	.5	Rework Scrap Use-as-is Work Order Update			Machining noforming .	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					ption of work order update		nitial	Action		Sign &		061
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descript	ion	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material	73/8/8	100 \$	411	He had	at inspeti that L sizes were 100 Bith help. ,204"/257" wee perseuri too heg!	(O 5	DAS 16 9-89	Pe Doyon hule on DFX to be : to be Declar o	s moluz	13,05,05	DAS 27 9-89 BQQ	DAS 16 9-89
Setup Other Process Supplier	13/0	100		RC. W	Beth help. ,204"/257" were nesseuri soo his!" s" our normal, oter set Taper.		, ०१/०१	SCRAP + Desly Replace. Bm124443	DHYD DHYD		• •	9)2042 13108/09
Training . Unapproved	_				A O'II			Dm12	· gm »			
					FA	٩UL	T CATE	GORY				
Landing	Gear				General							
	Bending Centre No Cracks	ot Conce	ntric to	o/s	Bend BOM/Route Broken/Damaged	\vdash	Grain Hardwa Inspect	are \$\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\		Ovalized Over/Under Part Incorred	 	Pressure/Forced Temperature/Cure Weld
	Crushed/	Crimped			Burrs	П	Instruc	tions Incomplete/Unc	lear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	•			Contamination	-		enance		Part Moved		•
	Heat Trea	at		<u> </u>	Countersink		Mislab	eled		Positioned V	Vrong	
	Inspection		Tube		Cut Too Short		Misrea	d		Power Loss/	Surge	Other
	Ripples in	-			Drill Holes		Offset			· 		
	Torque W	Vaves in 6	Extrusio	on	Drawing		Out of	Calibration				
	Turning S	equence			Finish		Out of	Sequence				
	Wave/Tw	ist in Tul	be		Folio	A	Outside	e Dimensions				

400570

riday, Septemb	ber 06, 2013	1:37:59 PM		"10h	5/3							Page	: 2
tem ID: Revision ID: tem Name:	D3870-5 Mount, Fwd U	Inner		Accept	*N900	040	100) *	Setup	Start Stop	_	S1*	
tem Name: Start Date: Required Date: Reference:	9/6/2013	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item II Customer:	D:					^IN;	S2*	
Approvals:		an:		Tooling: SPC (Y/N):	Date of the Date o					Start Stop		R1* R2*	
equence ID/ Vork Center II 30 *120* HandFinish land Finishing	D	Operation Description Chemical Conversion Co	oat per QSI005 4.1	Set Up/ Run Hours 0.00 Dis	Tool ID	Tool#	Plan Code	Accept Qty	Qty	N	Reject Rumber	Insp. Stamp	_
40 *140* *QC vuality Control		QCB Inspect Part Finish Memo		DAS 0.00 27 9-89 0.00 3 9,/C)			12		-			F-14
50 F150* Packaging ackaging		ldentify as per dwg & Sto	ock Location: <u>STC</u> S	0.00	·		-	12 ×	2	%	13-0	9-10	-

		,								DQA:	Date:	** , ′ ,
NCR: Y	Yes	/ No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	
Work Orde	sr.					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	- - No.					Rework Scrap Use-as-is Work Order Update	Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling									,			
Operator												
Material												
Setup												
Other					1							
Process												
Supplier												
Training												
Unapproved			1									

Landing Gear General Ovalized Pressure/Forced Bend Grain Bending Temperature/Cure BOM/Route Over/Under tolerance Centre Not Concentric to O/S Hardware Weld Cracks Broken/Damaged Inspection Incomplete Part Incorrect Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Burrs Instructions Incomplete/Unclear Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Inspection Strip in Tube Other Power Loss/Surge Cut Too Short Misread Drill Holes Offset Ripples in Bend Out of Calibration Torque Waves in Extrusion Drawing Finish Out of Sequence Turning Sequence

Outside Dimensions

FAULT CATEGORY

Wave/Twist in Tube

Folio

Work Order ID 106573

Quality Control

106573

Page 3

Friday, September 06, 2013 1:37:59 PM Item ID: D3870-5 Accept *N900040100* Setup Start **Revision ID:** Mount, Fwd Upper Item Name: 9/6/2013 Start Qty: 2.00 **Start Date: Cust Item ID: Required Date: 9/12/2013 Req'd Qty: 2.00 Customer:** Reference: Run Start **Approvals:** Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Tool ID Set Up/ Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description Qty **Run Hours** Code Qty Number Stamp 160 QC21- Final Inspection - Work Order Release 0.00 *160* 0.00 Memo

W138911

									DQA:	Date.	
NCR: Y	es / No				WORK ORDER NON-C	ON	FORN	MANCE / UPDATE	QA Closed:	Date:	,
				:	DISPOSITION			AGAINST D	EPARTMENT		
Work Orde	r:				Rework	, I		Skid-tube Crosstube	\neg	Water Jet	Engineering
Part N	0				Scrap		ľ	Machining Small Fab	Pro	od. Eng. Coor.	Quality
NCR N	lo	- ,		<u>-</u>	Use-as-is Work Order Update			noforming Finishing Large Fab Composite		re/Packaging Supplier	Other
Root				Descri	ption of work order update	lr	nitial	Action	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Description	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling				·					1		
Operator											
Material											
Setup										1	
Other										ļ.	
Process						İ					
Supplier									1		
Training [•			
Unapproved											
					F/	AULT	CATE	GORY			
Landir	ng Gear				General	_		_			•
	Bending			<u> </u>	Bend		Grain		Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to	o/s	BOM/Route	\square	Hardwa	re	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete	Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs		Instructi	ions Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance	Part Moved		-
	Heat Trea	it		٠	Countersink	\Box	Mislabe	led	Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

Friday, September 06, 2013 1:37:58 PM

Work Order ID:

106573

Parent Item:

D3870-5

Parent Item Name:

Mount, Fwd Upper

Start Date: 9/6/2013

Required Date: 9/12/2013

Page 1

Start Qty: 2.00

Required Qty: 2.00

124443 -> 2.2

Comments:

IPP Rev:A 09-01-20 as per prelim issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X04.000		Purchased	No			100	f	7.8340	0.2	0.4		/	
6061-T6 Bar .250 x 4.00									/acent			Ae 1.	3 ,09.0
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT		7 834							

7.834

124443

										DQA:	Date:	•
NCR: Y	es / No	ı			WORK ORDER NON-	100	NFORM	MANCE / UP	DATE			• ,
										QA Closed:	Date:	,
Work Orde	r:				DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is		i	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update	<u> </u>	,,,,,,,,	Large Fab	Composite		Supplier	
Root				Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling				ĺ.						ŀ		
Operator	_ ´			·								
Material							!					
Setup	_											
Other												
Process			.									
Supplier						1						
Training												
Unapproved												
						AUL	LT CATE	GORY				
Landii	ng Gear			_	General	_	7		_	¬		1
	Bendin	~		<u> </u>	Bend	\perp	Grain		<u> </u>	Ovalized		Pressure/Forced
		Not Conce	entric to	o/s	BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under		Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged		-i '	on Incomplete	<u> </u> _	Part Incorre		Weld
		d/Crimped	t		Burrs	<u> </u> _	┪	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination		Mainte		<u> </u>	Part Moved		
	Heat T	reat			Countersink	<u></u>	Mislabe			Positioned \	_	1
	Inspec	ion Strip i	n Tube	1	Cut Too Short	1	Misread	ł .		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

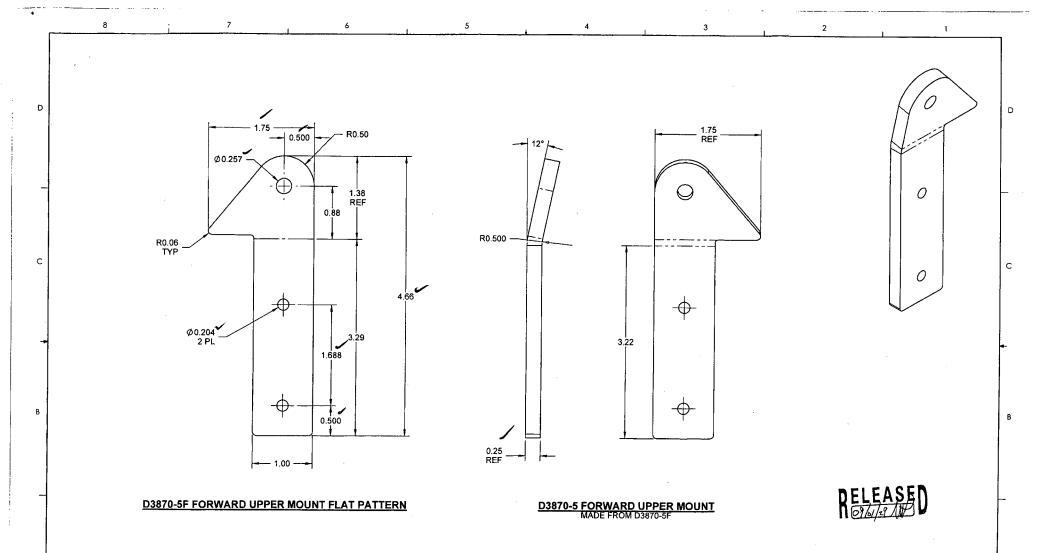
Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS O'THERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.04 lbs

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3870 MFG. APPR. SHEET 5 OF 5 APPROVED TITLE SCALE DE APPR. MOUNT NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS REPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR MAY PARROSE ON COMED OCCUMENTATION ON TO MEY PERSON WITHOUT
WHITTEN PERSON WOULD NAY ARROSPACE LTD. DATE 08.12.11

8

NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPD/

NCR: Y	'es	/ No				WORK ORDER NON-O	CONF	ORN	MANCE / UPDATE					
											QA Closed:	Dat	e:	· · · · · · · · · · · · · · · · · · ·
Nork Orde	r:					DISPOSITION		•	AGAINST	DEF	PARTMENT	/PROCESS		
Part N	lo.					Rework Scrap		ľ	Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor.		Engineering Quality
NCR N	lo.				<u></u>	Use-as-is Work Order Update	$\frac{1}{2}$		noforming Finishing Large Fab Composite	_	Rec/Sto	e/Packaging Supplier		Other
Root					Descri	ption of work order update	Init	ial	Action		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Chief	Eng	Description		Date	Verification		QC Inspector
oc/Data														
quip/Tooling														
perator														
1aterial										ı				
etup														
ther										ļ				
rocess							1			l			-	
upplier										ı				•
raining										l		٠		
napproved					L							S		
					·	F	AULT (CATE	GORY					
Landir	ng G	Gear				General	_		•			-	_,	
		Bending				Bend	Gr	rain		Ш	Ovalized	L	\neg	Pressure/Forced
		Centre No	ot Concer	itric to	o/s	BOM/Route	На	ardwa	re	Ш	Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged	lns	specti	on Incomplete	Ш	Part Incorred	ct [Weld
		Crushed/0	Crimped			Burrs	Ins	struct	ions Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
. [Cuffs				Contamination	М	ainte	nance		Part Moved			
		Heat Trea	it			Countersink	М	islabe	led		Positioned V	Vrong		
		Inspection	n Strip in	Tube		Cut Too Short	М	isread	ı İ		Power Loss/	Surge		Other
		Ripples in	Bend			Drill Holes	Of	ffset						
		Torque W	aves in E	xtrusio	n [Drawing	Or	ut of (Calibration					
		Turning So	equence			Finish		ut of S	Sequence					,
		Wave/Tw	ist in Tub	e		Folio	Ou	utside	Dimensions					

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	106573
Description: MOUNT, FUN UPPER	Part Number:	3870-5
Inspection Dwg: 3870 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø ,257	T.006001	,260			V	UKm-01
4.204	+ ,005001	,207			V	
1.75	+1030	1,74	_ `		V	
,500	+1010	,500			V	
,88	TI030	,88			V	
1.688	+1010	1.688			_ V	
,500	+1- ,010	,500			٧	
1.00	41030	1.00			_	
4.66	+1030	4.66				
-250	11- 010	,248	-		V	
3.29	+1030	3.29	-		V	
			·			
			<u></u>			
						· ·
			Ç A Q			

Measured by:	<i>Se</i>	Audited by:	0 20	Preliminary Approval:	
Date:	13.09.07	Date:	1399	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15

2nd Cut.

DART AEROSPACE LTD	Work Order:	106573	
Description: FWO UPPER MOUNT	Part Number:	03870-5	
Inspection Dwg: U3870 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
DO.204"	toos -0.001	0.204			U	Ikmo,
0.257	+0.005-0.001				V	
1.00"	4-0.030	1.014")		J	
0.500	11-0.010	0.20.	_		V	
1.688"	N	1.688	-		V	
4.66	11.0.030	4.669	_		V	
1.75"	i.	1.755"	J		>	
6.500"	H-0.010	°F02.0	-		۲	
O. 7 .5 5	11-0.030	0.246			V	
			,			
			:			
			DAS			
	l		27 9-89	L		

Measured by: Jm	Audited by:		F	Preliminary Approval:	
Date: 13-09-10	Date:	13910		Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15